

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001133**Date Inspected:** 02-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Mock-up**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

OBG Deck Mock-up Ultrasonic Testing

The QA inspector collected data and performed UT to the partial penetration joint(PJP) on the OBG Deck Mock-up. The results and the comparison between ZPMC and the QA inspectors values for the two connected panels at the junction of the deck plates to the U-ribs 1 thru 10, weld joints # 1 thru 10 were as listed on table and chart below:

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[illegible]

The QA inspector had a conversation with ABF representative Warren Buelher. The QA inspector informed Mr. Warren Buelher that the QA inspector found noticeable discrepancies on the length of the lack of penetration (LOP) marked ZPMC. The QA inspector informed that the QA inspectors performed verifications according with the ZPMC's UT procedure for testing the U-ribs welding (using the 6 dB drop method). The QA inspector added that the UT procedure is not identifying situations where the extremity of the LOP are extended using the 6 dB drop because the nature of the LOP. Mr. Warren Buelher agreed and said that ABF would search more about this issue.

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Quality Assurance Inspector

QA Reviewer